

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-203** Date Opened: **23 Nov. 2017** Title: **Assembly**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350** Product Type: **Cargo Basket** Product Model: **LH Medium** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
 Additional Work Sheets (Standard Practice)
 Drawings (See List Below)
 Parts Distribution Sheet
 Sub Component Tags
 Completed Certification
 Time Sheet (R&D)
 Notes

Initial or N/A

CB/JC
 N/A
 CB/JC
 CB/JC
 CB/JC
 JC
 N/A
 N/A

Build Sheet Contents

Tasks Initialled
 Dual Inspections Initialled

Initial or N/A

CB/JC
 CB/JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76410	3	Basket Assembly	CB/JC
70405	4	Lid Walkway Mod.	CB/JC
84240	0	Lid Brace Installation	CB/JC
84255	2	Handle Installation	CB/JC
76427	2	Placard	CB/JC

Traveller

Install walkway on lid
 Install lid on basket body
 Re-tap mounting lug holes and install mount lugs
 Install handle brackets
 Install handle
 Install lid prop
 Install data plate

Initial or N/A

CB/JR
 CB/JR
 CB/JR
 CB/JR
 CB/JR
 CB/JR
 CB/JR

Work performed by:

Print: C. Brander/J. RekveSign: Jan Rekve

SCA: AD01

Date: 23-Nov-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: J. Clarke

SCA: AD02

Date: 30 Nov 17

Work Order closed by:

Print: C. Brander/J. ClarkeSign: C. Brander

SCA: AD02

Date: 30 Nov 17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

Component Completion

Quantity Complete on This Work Order
 Quantity Incomplete on This Work Order
 Further Processing Required Before Release
 Release to Stock as Components

As Instructed

1
 N/A
 N/A
 N/A

Certification

Form One Completed
 Serviceable (Green) Tag Completed
 In Process (Yellow) Tag Completed
 Unserviceable (Red) Tag Completed
 Parts Placed in Stores for Distribution

Initial or N/A

JC
 DM/JC
 DM/JC
 N/A
 N/A

Additional Documentation

Documentation of a minor change
 Non-Conformance Report Required
 Service Difficulty Report Required

Initial or N/A

N/A
 N/A
 N/A

Billing

Local (Aero Design)
 Research and Development
 Third Party

Initial or N/A

JC
 N/A
 N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All Model: N/A

Description: Lid Walkway Checker Plate

Supplier: Ryerson

Color: Aluminum

WO#: N/A

PO# 17081



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: Multiple

Model: Multiple

Description: Hinge

Supplier: Bisco

Color: N/A

WO#: N/A

PO# 16030



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Medium basket handle No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 84261-01 Serial No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-31

Remaining Tasks to be Performed: Instal

Signature: [Signature]

Date: Feb 23/2018 Lic. No. / SCA AD-05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (LH Med ASSY) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 76410-01-02 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-60

Remaining Tasks to be Performed: ASSEMBLY

Signature: Jff Cel.

Date: 03 MAY 2017 Lic. No. / SCA 7002

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Med. Lid No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 69812-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-49-04

Remaining Tasks to be Performed: Clean up, Inspect,
Powder coat. ✓

Signature: David Prouty

Date: Oct 25/2017 Lic. No. / SCA 7304

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder PO 17105

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0444
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-203
6. Item 1.	7. Description Cargo Basket Ass'y	8. Part Number 76410-01-02	9. Qty. 1	10. Serial/Batch No. 76402-52	11. Status/Work New
12. Remarks Modified with walkway on lid and front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 30 Nov 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Wilderness Helicopters

Work Order: 2017-203Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

1 of 2

Date Opened: 23 Nov 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76410-01- <u>02</u>	Cargo Basket Assembly	(-01 RH, -02 LH)	<u>S/N 76402-52</u>
Step 1				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		<u>2017-49-04</u>
Step 1.a.	.. 3		49205-14	Bumper	Argus Industries Bumper	<u>See PDS</u>
	.. A/R		--	Sealant	Commercial Silicone RTV sealant	<u>N/A</u>
Step 1.b.	.. 1		76427-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	<u>N/A</u>
	.. 1		76427-02	Placard (left)	0.063 Sheet, 6061-T6 Aluminum	<u>2015-03</u>
	.. 4		CR3213-4-02	Cherry Rivet		<u>17070</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	.. 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>17091</u>
	.. A/R		CR3213-4-02	Cherry Rivet		<u>17070</u>
	.. A/R		--	Sealant	Commercial Silicone RTV sealant	<u>N/A</u>
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		76411-01-XX	Basket Body Assembly		<u>2017-60-</u>
	.. 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>See PDS</u>
	.. 8		NAS1149F0663P	Washer		<u>See PDS</u>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<u>16030</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>16063 + 15031</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>16053</u>
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	.. 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2017-150</u>
	.. 4		AN3-11A	Bolt		<u>See PDS</u>
	.. 8		NAS1149F0363P	Washer		<u>See PDS</u>
	.. 4		MS21044N3	Nut		<u>See PDS</u>

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Medium Basket Assembly

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-31
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	



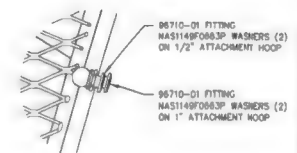
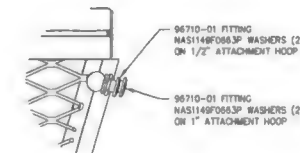
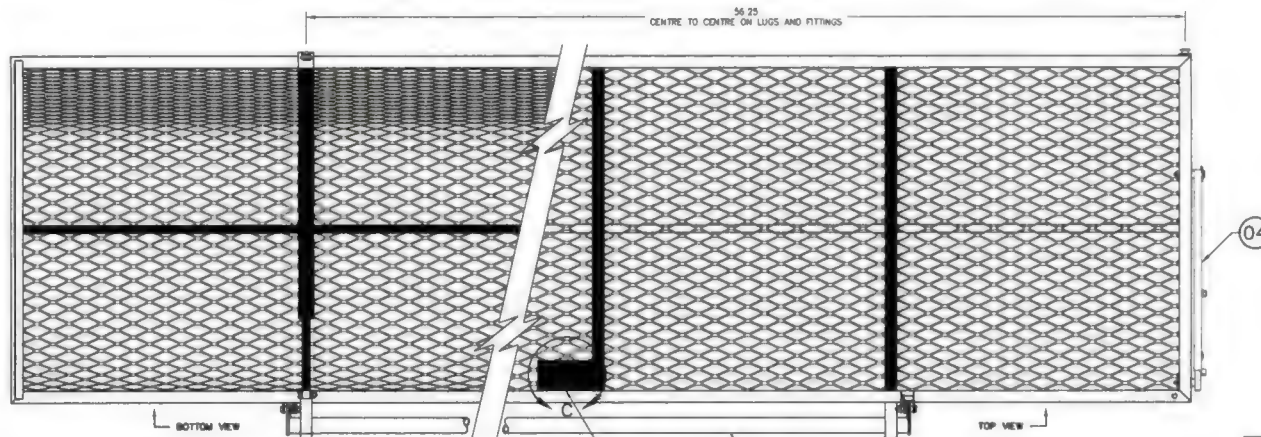
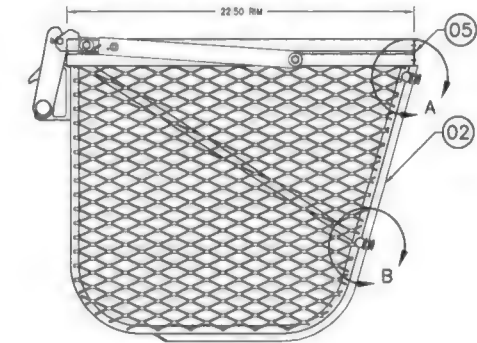
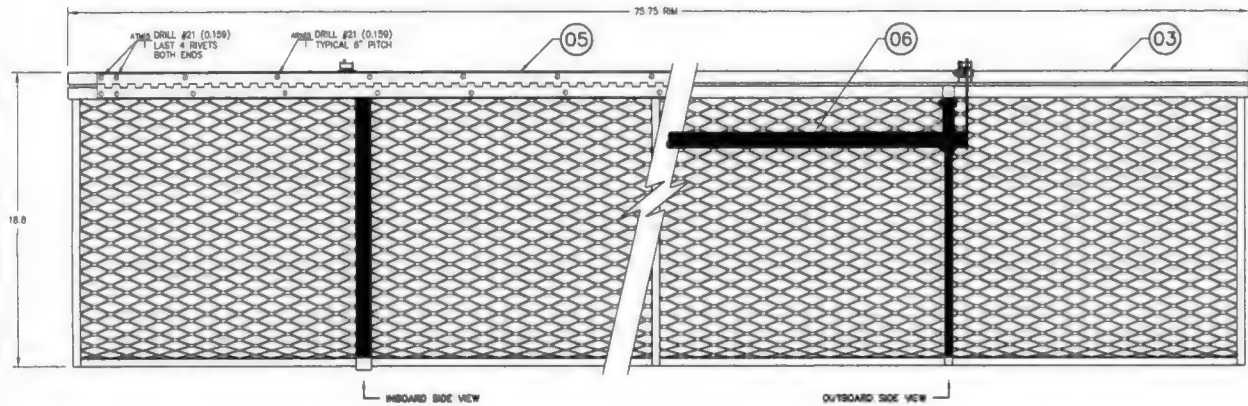
Description: Basket Assembly Kit

WO# 2017-203

2017-132 & ~~2017-132~~ 2016-132/22

S/N 76402-52

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	14 JAN 08
1	ADDED LH ASSEMBLY	RR	05 MAR 09
2	CHANGED HANDLE CONFIGURATION	BJC	27 JAN 10
3	UPDATE TITLE BLOCK, ADD ALTERNATE RIVETS, HARDWARE P/N'S UPDATED, CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	10/07/2014



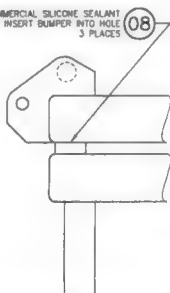
DETAIL A
SCALE 1:2
TYPICAL FRONT AND REAR

DETAIL B
SCALE 1:2
TYPICAL FRONT AND REAR

NOTE:
1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

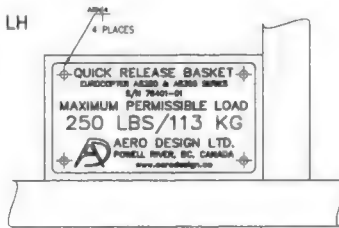
QTY	QTY	PART NO.	ITEM	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	4	NAS1149F0683P	WASHER			
1	1	06710-01	FITTING			
8	8	CR3523-5-02	CHESSY RIVET			
4	4	CR3213-5-02	CHESSY RIVET			
4	4	CR3213-4-02	CHESSY RIVET			
1	3	49205-14	OR BUMPER			
1	1	76427-02	O7 PLACARD			
1	1	76427-01	O7 PLACARD			
1	1	84255-01	O6 HANDLE BAR INSTALLATION			
1	1	MS20001P4	O5 TRIANG HINGE			72.0 LONG
1	1	84240-01	O4 LID BRACE INSTALLATION			
1	1	69812-01	O3 BASKET LID ASSEMBLY			
1	1	76411-01-02	O2 BASKET BODY ASSEMBLY (LH)			
1	1	76411-01-01	O2 BASKET BODY ASSEMBLY (RH)			
1	1	76410-01-02	O1-02 CARGO BASKET ASSEMBLY - LH			
1	1	76410-01-01	O1-01 CARGO BASKET ASSEMBLY - RH			

FILL 1/4" HOLE WITH COMMERCIAL SILICONE SEALANT
INSERT BUMPER INTO HOLE
3 PLACES



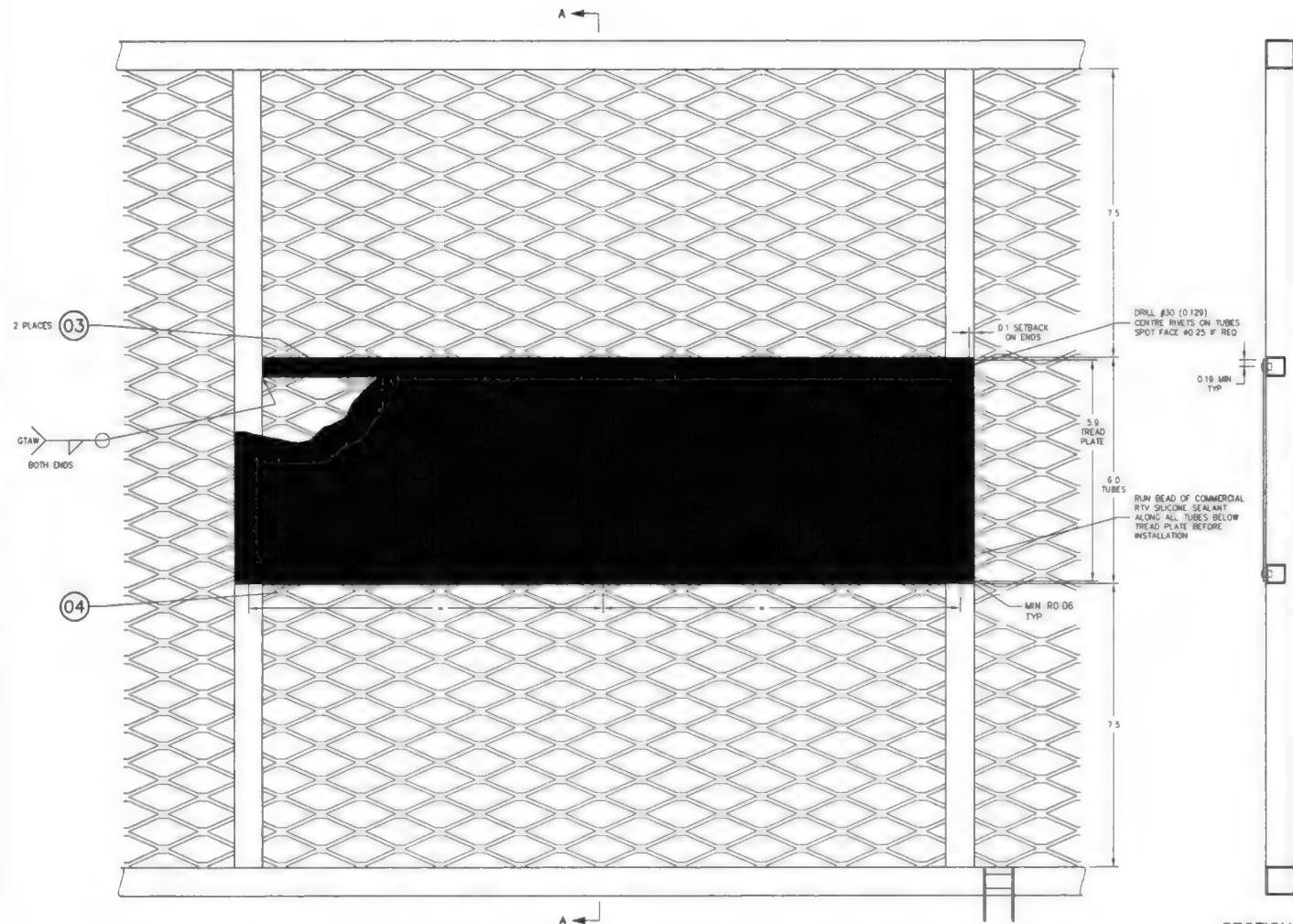
BUMPER INSTALLATION
SCALE 1:1

76410-01-01 CARGO BASKET ASSEMBLY - RH
SHOWN
76410-01-02 CARGO BASKET ASSEMBLY - LH
OPPOSITE



DETAIL C
SCALE 1:1
LOOKING AT PLACARD BRACKET

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: HAS 523	R=MTD HEAD NEAR SIDE F=MTD HEAD FAR SIDE	DRAWN: R RATHWELL	14 JAN 08
C=COUNTERSINK D=DIMPLE DGT=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	CHECKED: E BURGOIN	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1	
		AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 250.485.3276 www.aerodesign.ca	
		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY (MEDIUM)	
		SCALE 1:4	DWG SIZE
		SHEET 1 OF 1	A1 76410 3



(01) BASKET LID ASSEMBLY

SECTION A-A

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, AND USED FOR MANUFACTURING, WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BJC	29/05/2014

NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02		
1	70405-04 04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03 03	TUBE	4130 STEEL COND N	MIL-T-6738	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	BASKET LID ASSEMBLY				
1	70405-01 01	BASKET LID ASSEMBLY - MODIFIED WITH STEP				
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF NAS 523 C=COUNTERSINK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED BASIC CODES BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212		DASH NO FOR DIAMETER H=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE DASH NO FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E BURGON UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS: X XXX ±0.010 X XX ±0.03 X X ±0.1		DATE 21 SEPT 2008 AERO DESIGN LTD. 888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604 480 5370 www.aerodesign.ca	
CARGO BASKET LID STEP MODIFICATION				SCALE 1:15 SHEET 1 OF 1		DWG NO A1 70405	
				REV 4			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG, ADD LEFT PLACARD (02)	BJC	JAN 27/10
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 76401-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"250 LBS/113 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH

- ON 76427-02: S/N IS 76402-XX.

DRILL #30 (0.129)
4 PLACES




01 PLACARD

02 PLACARD

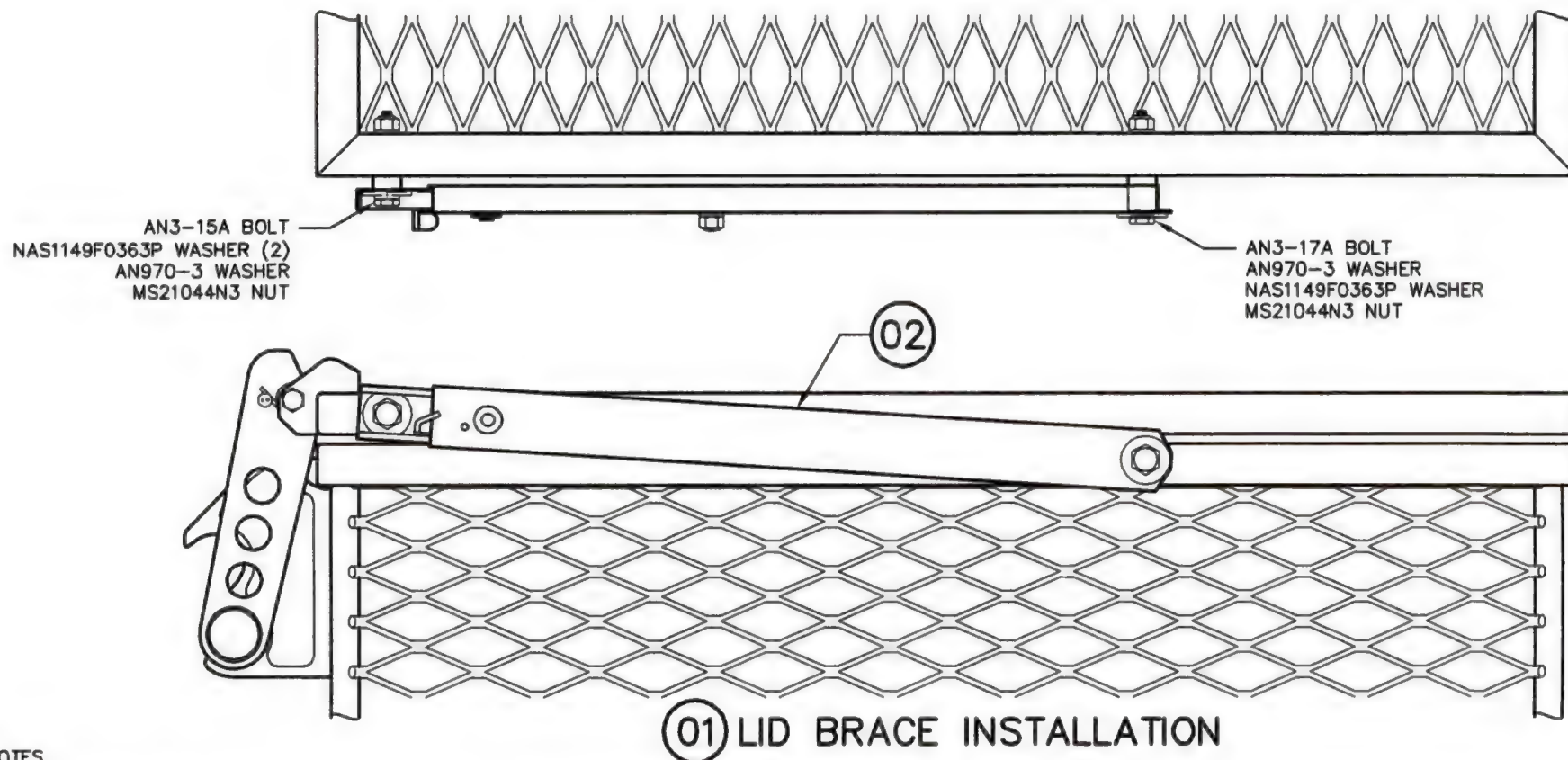
76427-02	02	PLACARD (LH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
76427-01	01	PLACARD (RH)	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS DRAWN: R. RATHWELL CHECKED: E. BURGOIN	DATE 18 FEB 08	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2378 www.aerodesign.ca	EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1							SCALE 1 : 1 SHEET 1 OF 1	DWG. SIZE A4	DWG. NO. 76427	REV. 2

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

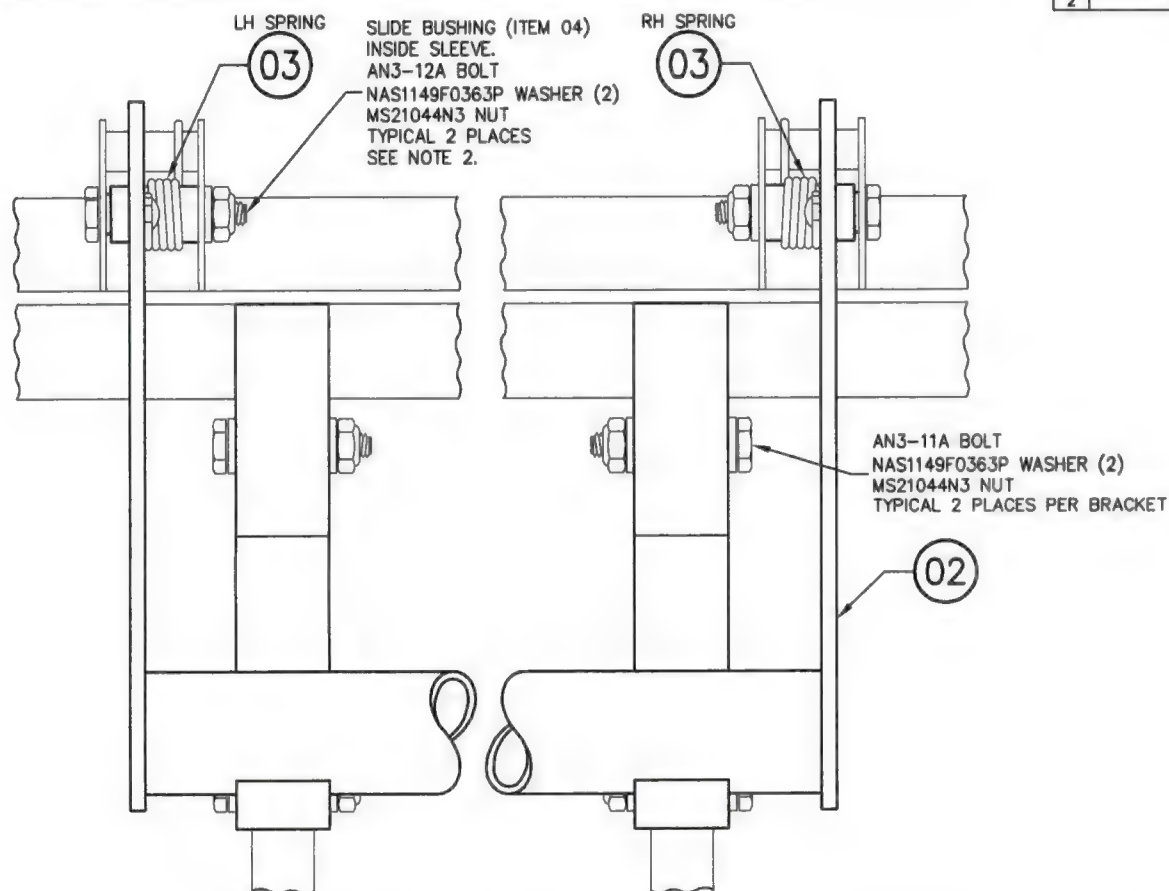
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

 AERO DESIGN LTD. 9000A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2375 www.aerodesign.ca		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION	
		NOT TO SCALE	REV.
DWG. SIZE	DWG. NO.		
A4	84240		0
SHEET 1 OF 1			

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

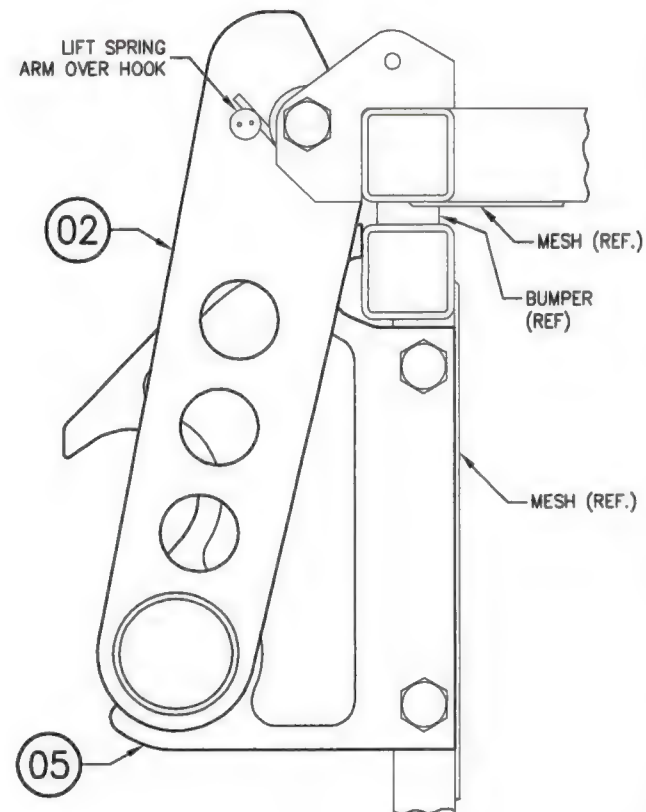


(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.488.2370 www.aerodesign.ca

HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-203

Date Open: 23 Nov 2017

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

✓	Basket Type	Basket			Lid Walk	Lid Prop	Handle		
		Ass'y	Placard	Mat'l			Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	80210	80227	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	80310	80327	Mat'l					Mat'l
	Long	81110	81127	Mat'l					Mat'l
Bell 206L/407 – Right side only									
	Low Standard	69810	69827	Mat'l	70405	84240	84255	84261	Mat'l
	Low Wide	94510	94527	Mat'l					Mat'l
	Low Ski	94610	94627	Mat'l					Mat'l
	High Ski	76610	76625	Mat'l					Mat'l
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	84240	84255	84261	Mat'l
	Extra Large (ski)	95510	95527	Mat'l					Mat'l
	Mega	100610	100627	Mat'l					Mat'l
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	84240	84255	84261	Mat'l
	Standard – Post S/N 71	95950	95927	Mat'l					Mat'l
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	84240	84255	84261	Mat'l
✓	Medium	76410	76427	Mat'l					Mat'l
	Long	78410	78427	Mat'l					Mat'l
	Ski	94010	94027	Mat'l					Mat'l
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	70405	84240	84255	84261	Mat'l
MD600									
	Standard	82810	82827	Mat'l	70405	84240	84255	84261	Mat'l

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
 - i. Locate sheet on basket.
 - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
 - i. Locate sheet on basket. Ensure sufficient clamps are in place.
 - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 766, 784 – 90"
 - 5. 940, 946, 959 – 95"
 - 6. 1006 – 107"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

CBOK

4. Install Handle

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

CB OK

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

N/A OK

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

AD
73-04
02

7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.